

Work Order ID 64422

Monday, December 06, 2010 8:53:44 AM

Page 1

Item ID: D2230-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 12/6/2010 Start Qty: 80.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 80.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/12/10

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

~~Jeaspa Bandsaw~~

Cut D2423 extrusion to 0.82"

Batch:

cut extrusion @ meter

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

issue 710 13073

to meter

machine as per dwg D2230 REV.G

CL 10/12/106 (80)

Purchasing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120
QC
Quality Control

~~QC2- Inspect parts off machine FAI/FAIB~~
rec'd + inspect fasteners & damage.
Memo

0.00

0.00

12/12/13 (80)

130
QC
Quality Control

QC3 Inspect parts - second check

Memo

0.00

0.00

80/12/14

count
(80)

150
HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

22/11 10/12/15

x 80 0

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Required Date: 12/13/2010 Req'd Qty: 80.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

80 BK 10-10-17.

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M15951

Memo

0.00

Powder Coating

START TIME: 9:20
OVEN TEMPERATURE: 320°
FINISH TIME: 9:50

80 BK 10-10-17.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 10/12/17 80 0

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Start Date: 12/6/2010 Start Qty: 80.00

Required Date: 12/13/2010 Req'd Qty: 80.00

Reference:

Cust Item ID:



Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging	Identify as per dwg & Stock Location: <u>476</u> Memo	0.00 0.00							<u>10/12/17 SP</u> <u>(Box)</u>
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/12/20</u> <u>MF</u> <u>10-12-17</u>

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NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 8:53:50 AM

Page 1

Work Order ID: 64422

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	565.8444	0.0683	5.751579			



Lug Extrusion



CX 10/12/06

Location

Loc Qty

Loc Code

MAT06

565.8444265

43722

180

45800

97.8444265

63005

288

5.751579

D 2230-3P

X80

12/12/13 (80)

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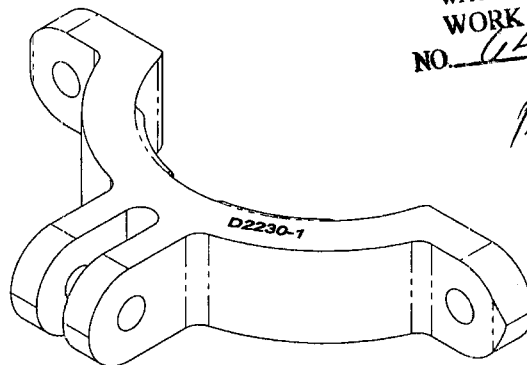
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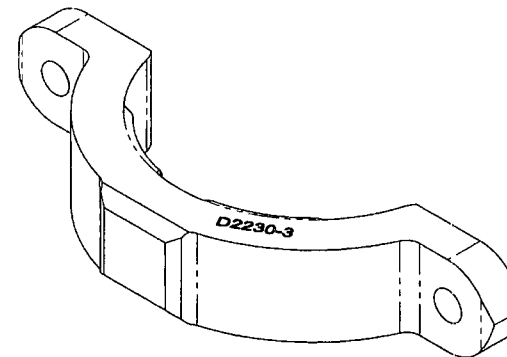
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6414 22

PS 10-12-4



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/08/15



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

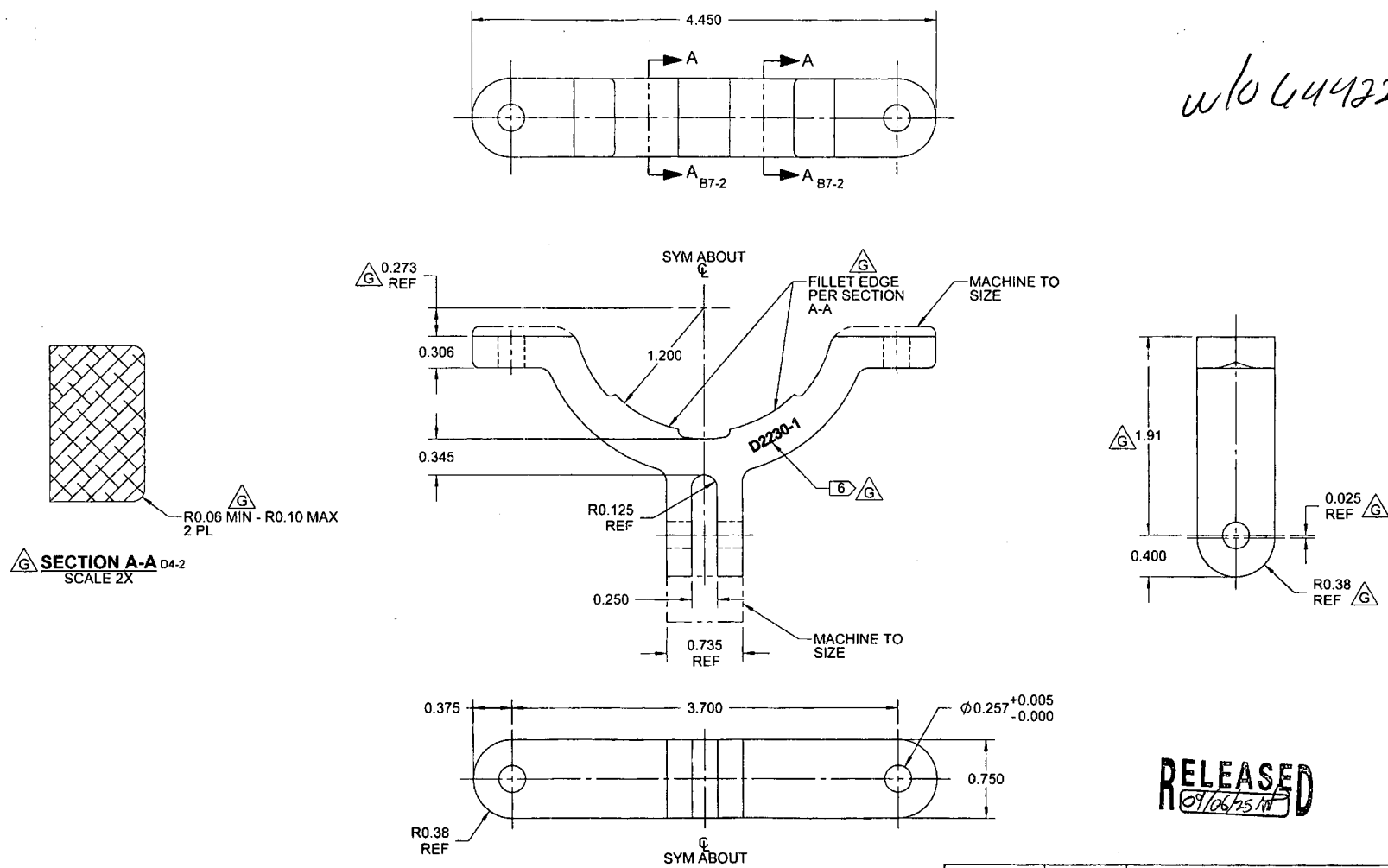
D

C

B

A

W1064422



RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G SHEET 2 OF 3
MFG. APPR.		TITLE MOUNTING LUG	SCALE NTS
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DE APPR.			
DATE	09.01.16		

8 7 6 5 4 3 2 1

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8 7 6 5 4 3 2 1

D

C

B

A

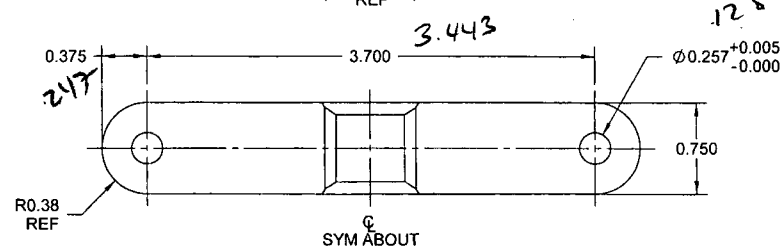
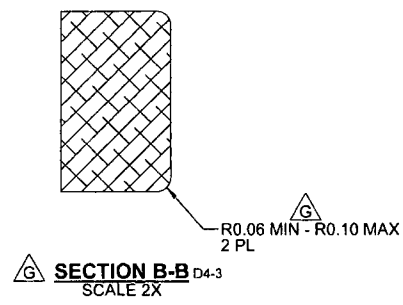
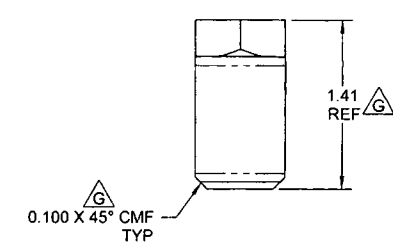
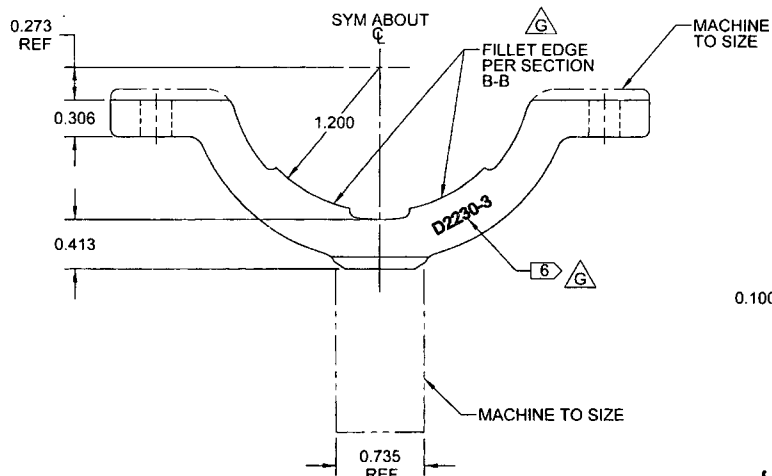
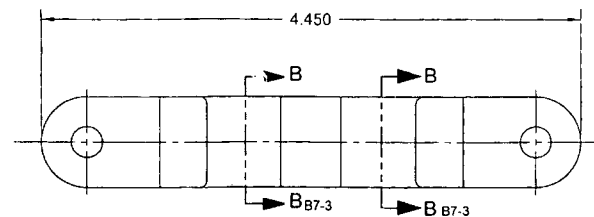
D

C

B

A

W064422



60

D2230-3 MOUNTING LUG

RELEASED
09/06/2014

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13073

Purchase Order Date 12/06/10

PO Print Date 12/06/10

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	12/17/10 Yes	80.00 Each	Yours ppd	\$18.9500	\$1,516.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B64423				
2	D2230-3P	LUG	12/17/10 Yes	80.00 Each	Yours ppd	\$10.4000	\$832.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B64422				

PO Total: \$2,348.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 12/06/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

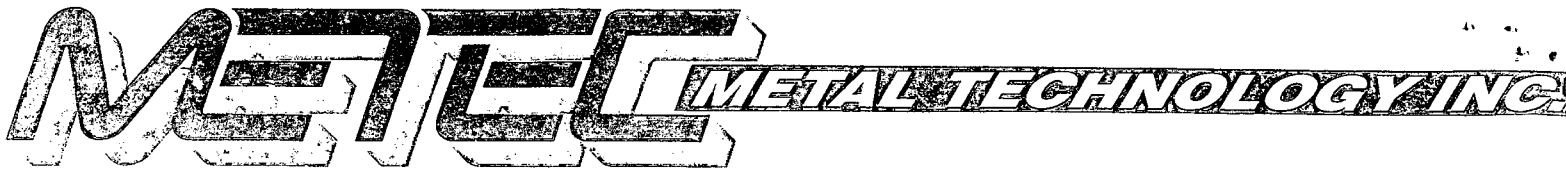


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17620
Date: Dec 10, 2010
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO 13073	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each	80	80	
D2230-3 Mounting Lug	Each	80	80	
<div>8 Dec 2/14</div> <div></div>				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

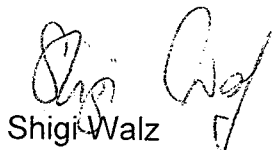
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2230-3	Mounting Lug	13000
80	D2230-3	Mounting Lug	13073
80	D2230-1	Mounting Lug	13073

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

8/10/12/14

Vankleek Hill, December 10, 2010